
125 Years of Toolmaking Excellence



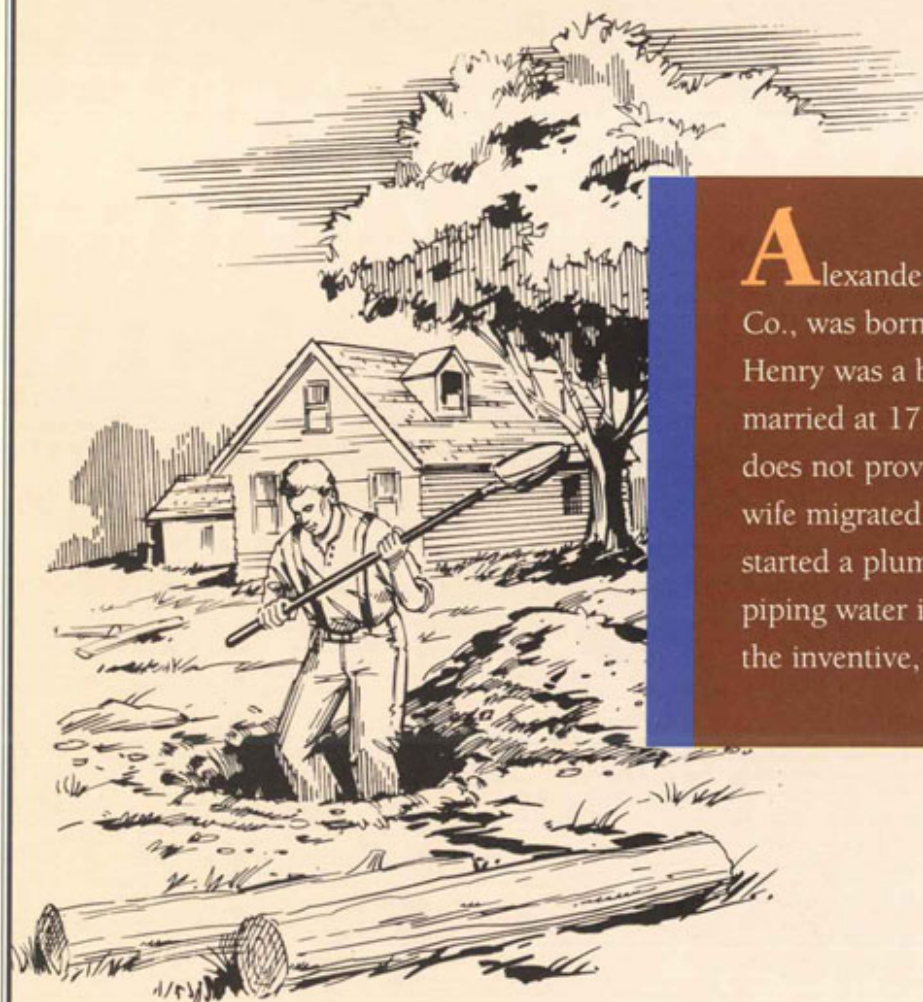
WAS A VERY SPECIAL YEAR!



We invite you to write for our catalog.

1869   **VAUGHAN**  OUR 125TH YEAR  1994

Vaughan's founding was one of a host of major events that took place in the year 1869, as described in this 125th Anniversary advertisement.



Alexander Vaughan, founder of what is today Vaughan & Bushnell Mfg. Co., was born in 1826 in Plattsburg, New York, to Henry and Mary Vaughan. Henry was a blacksmith, and Alexander learned the trade from his father. He married at 17, taking as his bride Mistress Elizabeth Scribner. Though history does not provide us with the reasons for their move, in 1844 he and his new wife migrated west to Peoria, Illinois. There, at the tender age of 18, Alexander started a plumbing business, which in those days consisted of digging wells and piping water into the kitchens of the local citizenry. His business prospered, but the inventive, young entrepreneur had his eye on bigger things ■

*A. Vaughan,
Post Auger.*

No. 91,387.

Patented June 15, 1869.

UNITED STATES PATENT OFFICE.

A. VAUGHAN, OF CHICAGO, ILLINOIS.

IMPROVED POST-AUGER.

Specification forming part of Letters Patent No. 91,387, dated June 15, 1869.

Fig. 1.

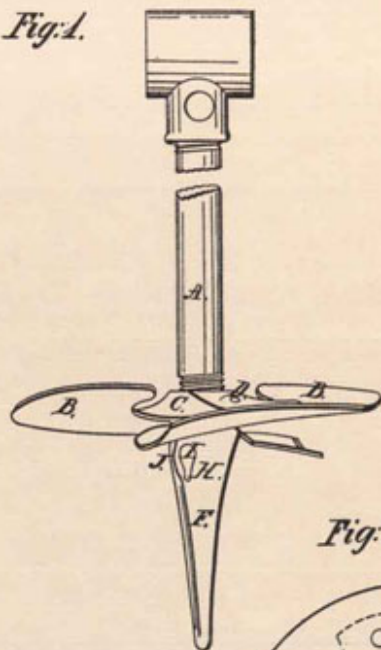


Fig. 2.

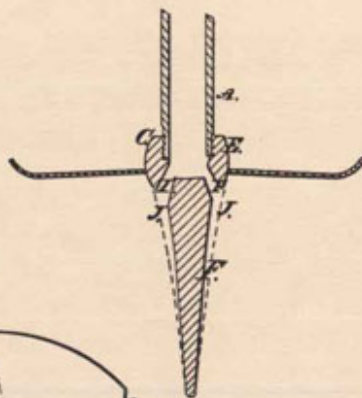
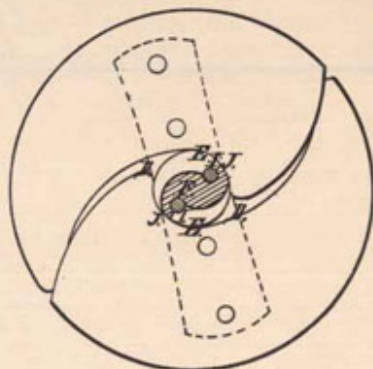


Fig. 3.



*Witnesses
G. L. Chapin.
E. E. Gibson.*

*Inventor
A. Vaughan.*

To all whom it may concern:

Be it known that I, A. VAUGHAN, of Chicago, in the county of Cook and State of Illinois, have invented a useful Improvement in Post-Augers; and I do hereby declare that the following is a full, clear, and exact description thereof, which will enable those skilled in the art to make and use the same, reference being had to the accompanying drawings and letters marked thereon, making a part of this specification, in which—

Figure 1 is an elevation of my improved post-auger; Fig. 2, a vertical section of the same; Fig. 3, a horizontal sectional view, looking upward.

The present invention relates to an improvement in that class of post-augers which are provided with hollow tubes to admit air into the post-hole when the earth above the auger is being removed; and its nature consists in the peculiar construction of the point, which is concaved out on its opposite sides and provided with ribs in front of conical holes, to prevent the latter from packing with earth when a post-hole is being sunk, said point being cast solid to the arms which support the lips of the auger, and conveniently arranged to fasten to the hollow shank, as hereinafter fully shown.

F represents the point of the auger, which is made of cast metal, and provided with arms D for the support of the lips B B, and with a cylindrical cavity in its upper end for the

reception of the tubular shank A, which is screwed fast to it, as shown at Fig. 2. The opposite sides H of the point are so concaved out as to form ribs, J, which project outward and beyond the holes I, and prevent them from being packed with earth when a post-hole is being dug. The holes I communicate with the tube A, and their lower ends are made the largest, in order that if loose earth should by any means pass into them, it will fall out by its own gravity, or be readily forced out by the pressure of atmosphere when the auger is lifted up, instead of its sticking fast, as is the case when the holes have a cylindrical form. By means of these concave sides, the holes I can be made more nearly vertical than when the point is conical or square, and at the same time at less cost, as they are so much shorter, and consequently require less drilling.

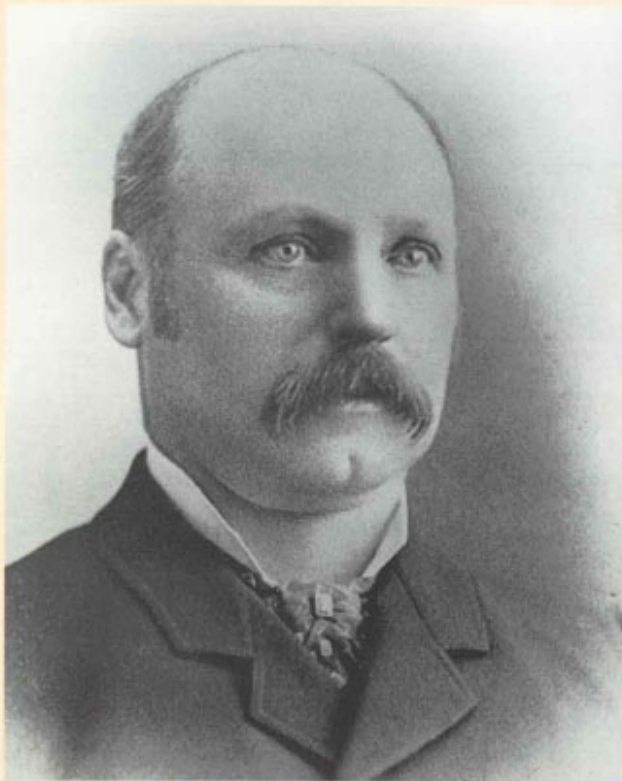
Having thus fully described my invention, what I claim, and desire to secure by Letters Patent of the United States, is—

In the construction of post-augers, the point F, which is provided with recesses on its opposite sides, conical holes I I, communicating with the tubular shank, and ribs J J, protecting the holes from earth, and also with arms D D for the support of the lips B B, as set forth and shown.

A. VAUGHAN.

Witnesses:

G. L. CHAPIN,
E. E. GIBSON.



*Alexander Vaughan,
Founder and first President*

It was about that time that the split-rail fencing of farmland was beginning to be replaced by steel posts and wire, and while working in the earth, Alexander had an idea for improving the design of the augers used for digging post holes. He turned idea into reality, and recognizing that Chicago was likely to outstrip Peoria as a manufacturing center, moved to the Windy City. He set up a blacksmith shop in a dirt-floored room behind a hardware store owned by one Sidney S. Bushnell. It is a measure of the sophistication of the times that the dirt floor of his rented quarters also served as a test bed for refinements to his auger design. On June 15, 1869, Alexander was granted U.S. Patent No. 91,387 for his "Improved Post Auger".

Customer satisfaction with Vaughan post augers led to requests for other hand tools, and Alexander soon found himself in the custom tool business. His habit was to make three or four samples of each tool, supplying one to the original customer and putting the others up for sale■



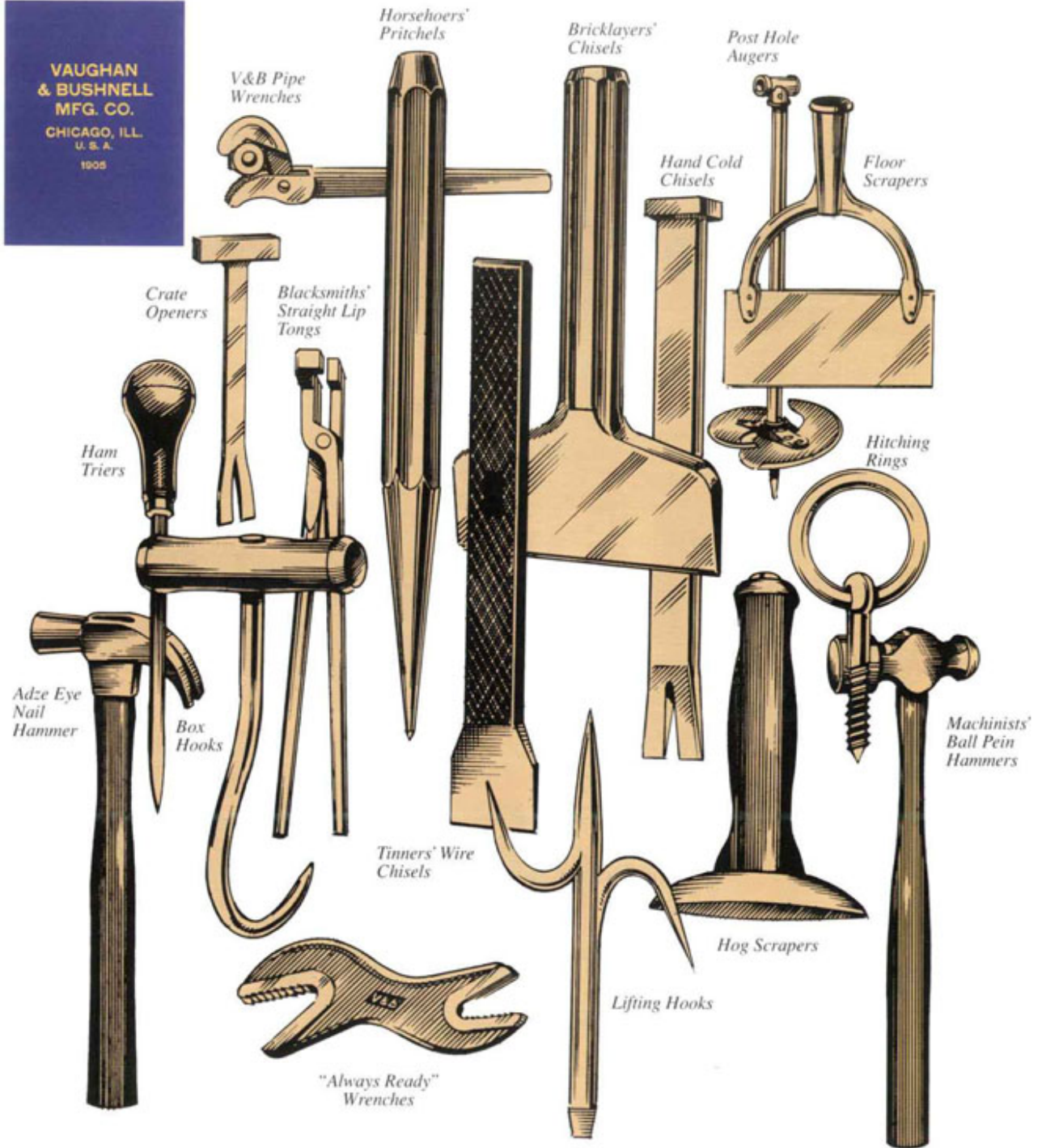
1882—VAUGHAN & BUSHNELL IS FORMED



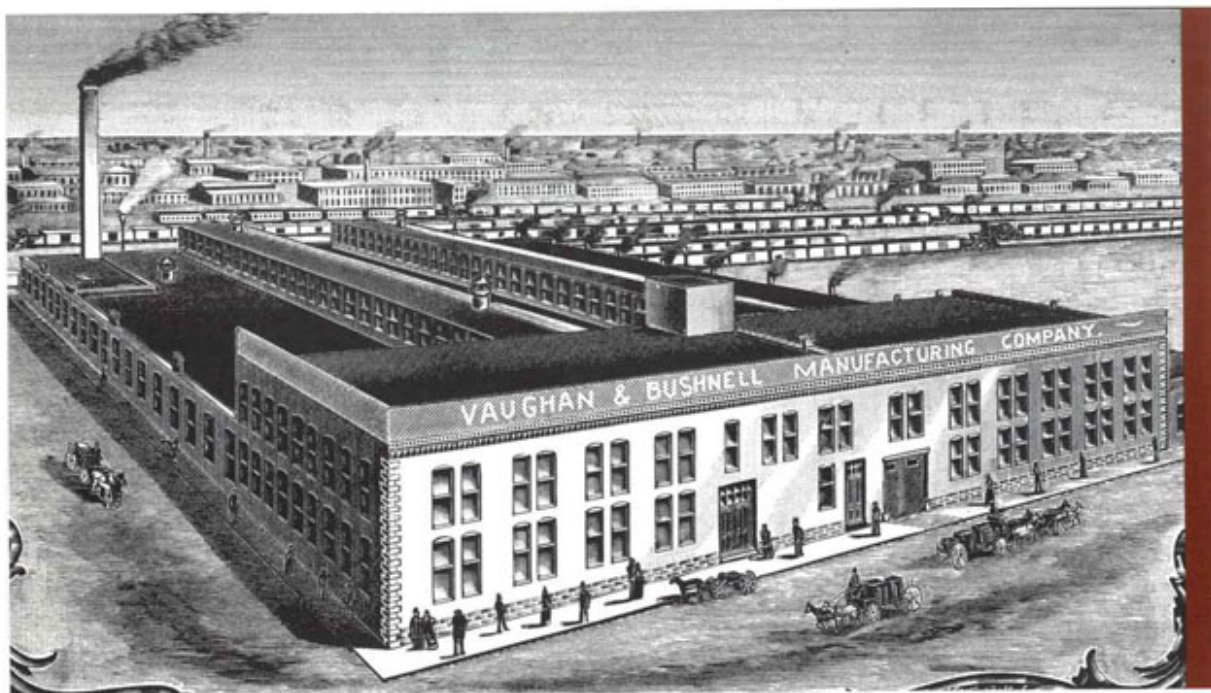
There were several Vaughan salesmen traveling the Mississippi and Missouri River valleys selling augers and other tools when tragedy struck in the form of a fire in 1871. A fire which—legend has it—was started when Mrs. O’Leary’s cow kicked over a lantern. It was a fire which not only destroyed the fledgling Vaughan business, but much of Chicago as well. In the aftermath of the Great Chicago Fire the strained finances of the Vaughan Company

prompted a hunt for additional capital. Sidney Bushnell and his son Lemuel offered to furnish the needed funds, and thus began the Vaughan & Bushnell partnership. The company opened for business at 11 South Halsted Street in Chicago, but soon moved to larger quarters at 106—108 West Randolph Street in Chicago, a site that is today occupied by the State of Illinois Building. The company was incorporated in 1882 as the Vaughan & Bushnell Mfg. Co ■

By this time Vaughan's product line had grown to include quite a variety of tools and implements. One of the first Vaughan hammers, a so-called "killing hammer", was in great demand for delivering the *coup de grace* to cattle being processed at the then-flourishing Chicago Union Stock Yards. Besides hammers, such staple tools as those needed for blacksmithing and shoemaking were also being manufactured, together with chisels, punches, pincers, nippers, star drills, planes, wrecking bars and pliers. One notable product marketing failure was a hair curling iron which never caught on with the ladies■



1897—EXPANDED PRODUCT LINE



Artist's conception of Vaughan's Carroll Ave. Plant, c. 1903



*Vaughan ball pein
and nail hammers,
c. 1903-'05.*



V&B "Eagle Brand" head stamp

Sanford S. Vaughan, Alexander and Elizabeth's only son, joined the company in 1886, just before a move to larger facilities at 2114 Carroll Avenue in Chicago. By 1897 Vaughan was employing 40 people, and Sanford was in charge of a manufacturing plant where the work schedule called for 10 hour days, six days a week. It was the custom in those days to pay all employees in cash every Saturday at noon. This practice continued until about 1900, when one of the company officers was held up on his way from the bank and relieved of the weekly payroll. The two holdup men were caught the same afternoon and most of the cash recovered, but from that time on employees were paid by check ■

Vaughan in 1897 boasted a product line that included more than 50 different tools in a range of weights and sizes. As time passed, those items which progress had made obsolete were dropped from the line, and others—including more hammers and a variety of hatchets and axes—were added. The great demand for hammers, hatchets, axes and wrecking bars soon made them the primary items in the line, and Vaughan eventually came to specialize in the manufacture of hammers and other striking tools. Steam engines provided the motive power in the plant at this time, and all machinery was belt driven. Vaughan converted from steam to electric power about 1910, although illumination was still provided by gas lights, electric lights not yet being in general use. A three-story addition was built onto the west end of the Carroll Avenue plant in 1898, and a five-story building was added to the east end of the plant in 1910. About 1915, the pressure of still more growth prompted the company to build a two-story building across the street from the main plant ■



During this period, Vaughan was manufacturing a variety of tools under the V&B and Garden City brand names.



1905—SANFORD S. VAUGHAN BECOMES PRESIDENT



TERMS OF WARRANTY.

VAUGHAN
& BUSHNELL
MFG. CO.
CHICAGO, ILL.
U. S. A.
1905



Warranty Statement
from the 1903

Vaughan Catalog

If any of our tools, stamped V. & B., prove to be too soft or too hard, or are defective in the steel, if returned to us, we will gladly replace without charge.

All the goods we manufacture are closely inspected and severely tested to detect any flaws that may exist.

The Steel these goods are manufactured from (which is equal to any in the market) is made expressly for the class of goods for which we use it, so that every tool is perfect in material, construction, workmanship and finish.

It was also in 1897 that Vaughan began supplying private label hammers to Sears, Roebuck and Co. The relationship continues to this day, and Vaughan ranks as Sears' oldest supplier.

Vaughan's dedication to making high quality products has been integral to the company's work ethic from the first. The following little excerpt illustrates the point. It is taken from a recollection of his early days with Vaughan, written by Emil Nordell, who came to work for Vaughan in 1897 at the age of 17. He retired in 1957 after 60 years with the company.

"A first class job was expected from each man, and we were all eager and willing to do our part. All hammers were given a severe physical test. In addition, nail hammer claws were tested using three different sizes of nails. All first quality hammers had to pull the smallest brad. The double octagon nail hammer was full polished and given a mirror finish before being nickel plated and buffed. The handles of plated nail hammers were hickory with a black ebony finish that was hand rubbed and equal to any piano finish."



Sanford S. Vaughan,

Alexander Vaughan remained active in the business until about 1900. Upon Alexander's death in 1905, Sanford took over full management of the company. Sanford Vaughan was an innovator and made many basic changes in the design of the traditional carpenter's hammer. He gave the formerly stubby claw a more open sweep, and crowned the hammer cheeks to provide more strength to the eye, both of which changes are to be found in all hammers being made today. Handle-to-head wedging was improved, and Vaughan patented the triple-wedge design. In 1918 Vaughan introduced the classic "999" pattern ripping hammer, named by Sanford after the famous New York Central No. 999 4-4-0 steam engine, which set a speed record on a run from New York to Chicago. Charles Bushnell, Lemuel's son, also entered the business about 1900, and continued as an officer of the company until 1922, at which time the interests of the Bushnell family were purchased by the Vaughan family. Sanford served the company for 65 years until his death in 1951 ■

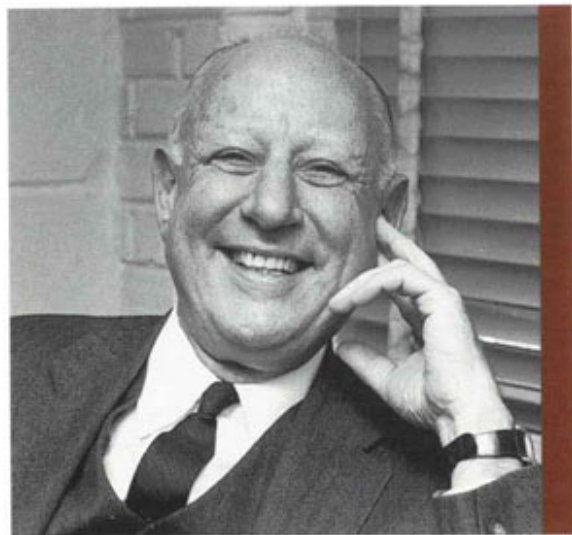


The open sweep of the claws on nail hammers was a Vaughan innovation

Originated by Vaughan in 1918, the "999" Rip Hammer was named after the famous New York Central steam locomotive.

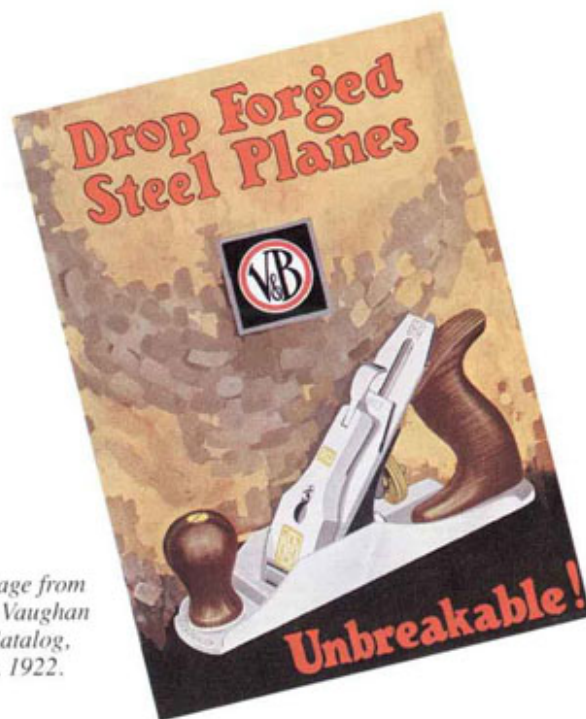


1945—HOWARD A. VAUGHAN, Sr., PRESIDENT



Howard A. Vaughan, Sr.,
President from 1945 to 1966

Sanford's son, Howard Sr., joined the company in 1922. He was named President and Chief Executive Officer in 1945. One of his major concerns was that demand for tools—both those carrying the Vaughan label and those of the many private label brands which Vaughan was by then supplying—would soon outstrip the capacity of the Carroll Avenue plant. A major expansion was clearly needed, but impossible to provide at that location. In 1940 the company was invited to display some of its products at a dealer show sponsored by a leading hardware distributor in Chicago. As it happened, C.S. Norcross & Sons, a garden tool manufacturer, occupied an adjoining booth. Norcross was located in



Page from
a Vaughan
Catalog,
c. 1922.



Photo c. 1936, picturing Vaughan employees with 20 to 54 years of service



There are two kinds of particular merit that should be in every carpenter's tool chest—V & B Vaughan Planes and V & B Unbreakable Planes!

V & B Vaughan Planes are made from V & B drop-forged steels, steel and handled with the finest factory. They are designed, machined and tested to work with a new gripping, special velocity view.

V & B Unbreakable Planes won't warp when dropped. They are drop tested and guaranteed. A full line of V & B is represented throughout with all reasonable credit terms, cash or deferred at the way to the job.

Your hardware dealer will readily recommend these new tools. Ask for the time when you are in.

VAUGHAN & BUSHNELL
MANUFACTURING COMPANY
BRIDGE OF THE FUTURE
312 Carroll Ave. Chicago, Ill. U.S.A.

Bushnell, Illinois, and the conversation between Howard Vaughan and Charles Norcross naturally turned to the coincidence of names. Impressed by Norcross' description of the town and its advantages, Howard and other company officers made several visits to Bushnell, culminating in the purchase of a building there in the summer of 1940.

Limited manufacturing commenced in Bushnell in the fall of 1940, and was gradually expanded during World War II. The town's location and ample labor supply proved so favorable that, in 1950, it was decided to consolidate all manufacturing operations at Bushnell. ■



*Quick-grip
claws that hang
on. You'll never
break them.*

VAUGHAN'S VANADIUM

The Aristocrat Among Hammers and the Pride of Every Carpenter Who Uses It.

SWINGS EASIER — HITS HARDER — LASTS LONGER

There's a "Close" in this hammer that makes every other hammer look cheap and clumsy. And "its" history is more than white wash. For our registered trademark VANADIUM TOOL STEEL gives it tremendous strength, and the power is built around that would work any other hammer. For instance, those shoulder, long-hand claws will stand proof that would break over the thick head alone on hammer made of ordinary steel. And the close and hammer-face won't "nick" like other hammers.



Head-
Shaved
Second-
growth
HICKORY
Handle



A patented aluminum expansion wedge forces the handle head on like pins work, and the wedge is made of the same material as the work with a tapered shank in a 10° angle. This wedge is made of the same material as the work, and is the only one, one into the wood. It is made of the same material as the work, and is the only one, one into the wood. It is made of the same material as the work, and is the only one, one into the wood.

It's a hammer that works with the least effort; and its head without jarring the hand. That's why we build under the guarantee, requested, literary handle, strike a blow into concrete or any other dead surface with this hammer; then with any other make and, instantly, note the difference.

Put it into your kit. It will make you proud of your good judgment every time you use it.

HOW TO GET ONE

First to your hardware store. Look for the "Vaughan's Vanadium" mark on the handle. If you don't find one, a letter to us will get it. We will send you the name and address of the dealer you need to join. We will only join the hammer to your own ground.

Ask Your Dealer.
If he has none in stock order from us.

**VAUGHAN & BUSHNELL
MANUFACTURING COMPANY**
Makers of Fine Tools
208 Carroll Ave. — Chicago, Ill. U.S.A.

HARDWARE AGE

February 7, 1954

YOU SELL HAMMERS!

When the hammer is stamped V & B you are selling a guarantee of satisfactory performance as well! Drop forged from special analysis steel in positive draw—dividually tempered and treated—they are uniform in shape and performance.

The non-slip claw (3) is specially designed to firmly grip any size nail from head to spike, and the shape of the sweeping prongs, for maximum leverage, with least effort, when pulling. The extreme ends of the claw are ground as thin as pencil for prying.

The sides of all V & B nail hammers are carefully crowned to prevent jamming, used in shearing flooring and subflooring, and the face (1) is crowned to prevent tearing of sheetwork when driving.

The blinding eye (2), which is forged wider at the center than at the ends, acts as a positive lock to hold the handle tight and secure.

Only the best of material goes into making a good hammer (4), which are designed to give you the right bang and balance to the hammer.

They sell for the thousands every year! Stock them—*now!*

**VAUGHAN & BUSHNELL
MANUFACTURING COMPANY**
MAKERS OF *Plane Tools*
214 Carroll Ave. • Chicago, Ill., U.S.A.

VB

[illegible]

A page from the 1958 Sears catalog. Vaughan has been supplying tools to Sears, Roebuck and Co. since 1897, and ranks as the retailer's oldest supplier.

Early Vaughan ads from (l.to r.) 1925 and 1928 issues of The Carpenter, and from a 1924 issue of Hardware Age.

1966—HOWARD A. VAUGHAN Jr., PRESIDENT

In many respects the image of Vaughan & Bushnell today is a reflection of Howard A. Vaughan, Jr. He joined the company in 1956, was named Vice President of Sales in 1960 and became President in 1966. Vaughan during that time was a major supplier of striking tools, both under its own name and a variety of other proprietary brands, as well. Taking as his goal a substantial increase in sales of Vaughan-labeled tools, Howard Jr. first undertook a major modernization of Vaughan's manufacturing processes to ensure that adequate production capacity would be available to absorb a market expansion. New, high efficiency forges were installed, and many manual



Howard A. Vaughan, Jr., named President in 1966



A selection of Vaughan ads, from 1972 to the present

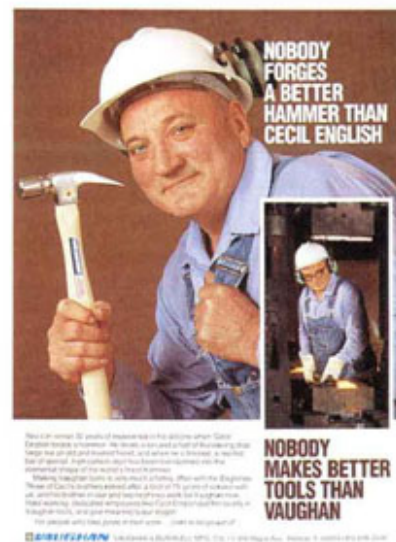


finishing procedures were automated for better control and more consistent quality. A CAD/CAM system was put in place, providing greater efficiency in the design and production of dies and forgings, and shortening the design lead time for the new hammers that were being added to the line.

A more aggressive marketing and advertising program was begun, aimed primarily at the hardware wholesalers and retailers that were needed to expand Vaughan's reach in that marketplace, and Howard Vaughan spearheaded a successful drive to increase distribution, both nationally and internationally. The new products added to the line further enhanced Vaughan's position as the single source for all

types and styles of striking tools. The company's offering of soft face hammers and mallets was expanded to allow greater penetration into industrial markets.

Vaughan's insistence on consistently high quality was recognized when, in 1993, the company became the first striking tool manufacturer in the world to be awarded the International Standards Organization ISO 9002 Certification, together with British BS 5750 Part 2 and European EN 29002 Certifications. Extending beyond manufactured product quality standards, these certifications include all aspects of operations in Vaughan plants ■



1992—GROUNDBREAKERS INTRODUCED

In 1963 the administrative headquarters of the company were established in new offices and plant in Hebron, Illinois. A subsidiary, The V&B Mfg. Co., was formed in 1966, and a plant built for the manufacture of hickory handles. Located in Walnut Ridge, Arkansas, V&B Mfg. ensured availability of top quality handles. In 1992, GroundBreakers® landscaping tools were added to the product line. Innovative in design and construction, they quickly found wide acceptance among landscapers, contractors and home gardeners. Vaughan in 1994 acquired a sawmill in Centerville, Tennessee. This facility, situated in the heart of a hickory forest belt, guarantees Vaughan a virtually unlimited supply of the highest quality hickory for both striking tools and GroundBreakers landscaping tools ■



(Above) Vaughan originated many hickory handle designs that have subsequently become industry standards. (Right) A recent ad for GroundBreakers landscaping tools.

GROUNDBREAKERS®
are Profit Makers!

Nine distinctive tools designed to meet every landscaping need.

New!
36" & 26" Handles
for Handy Series
Tools.

GroundBreakers are popular with both landscape contractors and home gardeners. Their wide choice of styles lets your customers choose exactly the right tool for the task at hand. GroundBreakers are nicely balanced tools, with head weights and handle shapes that make them swing easy and strike right. And GroundBreakers are strong, cast of tough ductile iron, reinforced at stress points. You can sell them with confidence that they'll handle the toughest jobs. Call or write for information literature and prices.

GROUNDBREAKERS®
LANDSCAPING TOOLS
V&B
2101 MANUFACTURING CO.
P.O. Box 108, Hebron, Illinois 60141
Tel: 815-462-4100 • Fax: 815-462-4101

See today's
V&B Tools
New Catalog
800-1

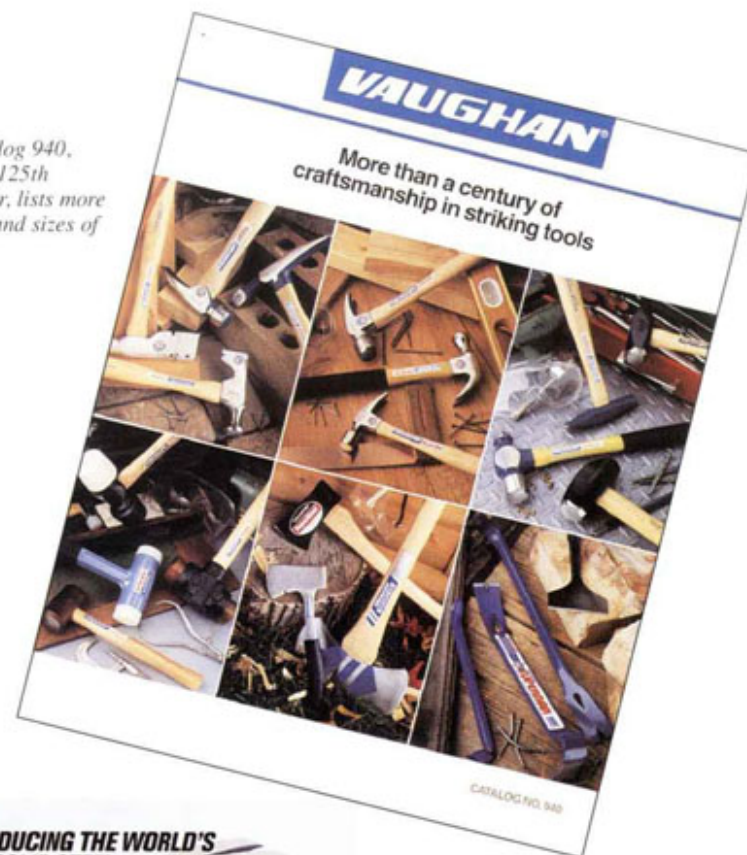
Vaughan corporate headquarters in Hebron, Illinois.





Over the years, Vaughan has been privileged to manufacture tools under some of the country's most recognized brand names, a few of which are pictured here. Attracted by Vaughan's reputation for quality products, these marketers have come to rely on Vaughan for its ability to meet the most demanding production deadlines, as well.

Vaughan's Catalog 940, released in this 125th Anniversary Year, lists more than 200 types and sizes of striking tools.

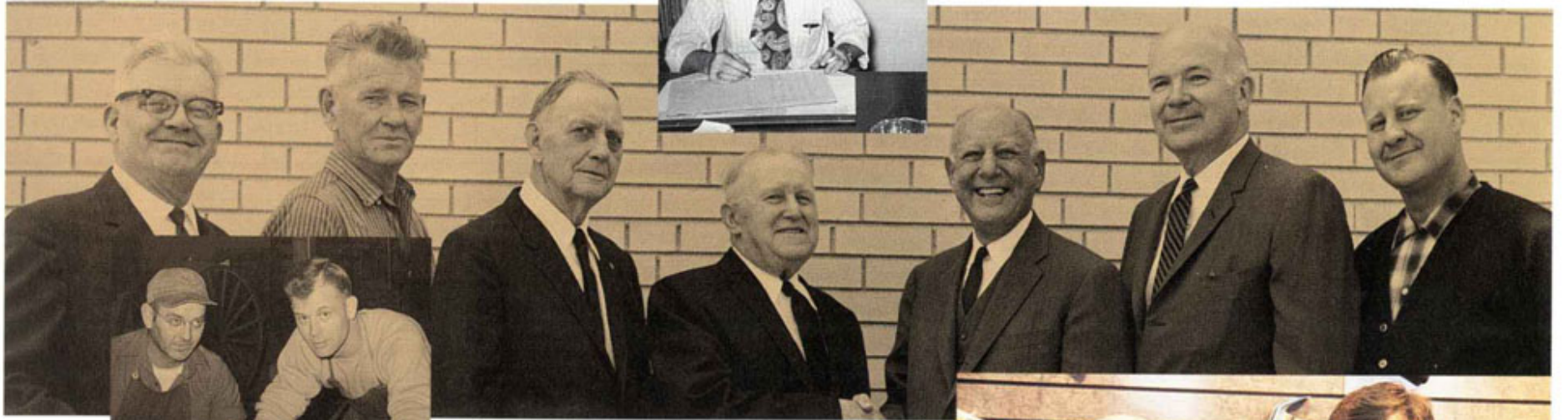


The introduction of Steel Eagle® Hammers in 1994 is the latest example of Vaughan's continuing program of innovation in striking tool design.

1869-1994—PEOPLE TO BE PROUD OF



Today's Vaughan & Bushnell is of a size and sophistication that Alexander Vaughan could scarcely have imagined. While new manufacturing techniques and processes have played a part, the people of Vaughan are the real foundation of the company's success. Dedicated to the goal of producing the finest striking tools in the world, they have helped transform Vaughan from a small maker of hand tools to the world's largest manufacturer of striking tools. Vaughan tools are made with an attention to detail that is exceptional. Four generations of the Vaughan family and the dedicated craftsmen who produce their products care a great deal about the tools that carry the Vaughan name, and the care is obvious ■





VAUGHAN

*For people who take pride in their work . . .
tools to be proud of*

VAUGHAN & BUSHNELL MANUFACTURING CO.
11414 Maple Avenue, Hebron, IL 60034
815 648-2446 • FAX 815 648-4300